

Date: Wednesday, 01/10/2008 11:33:27 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TURNING DETAIL FOR D2940-1
Job Number	: 42375		
Estimate Number	: 13237		
P.O. Number	:	Part Number	: DSK081
This Issue	: 01/10/2008 S.O. No. :	Drawing Number	: DSK081 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 41529	Material	:
Written By	:	Due Date	: 15/10/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JULIE LECOCQ</u>		
Comment	: est rev A. 08.03.13 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6104007	Round Billet, 17-4
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

BATCH: B41967

J.F. 08/10/04

(10)

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: ~~MORI SEIKI CNC LATHE LARGE~~  
 Turn blank as per Folio FA079

Doosan

J.F. 08/10/04

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/10/04

(10)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 08/10/04

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Identify and Stock in Kanban  
 Location: CNC

J.F. 08/10/04

(10)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08

Job Completion



MF 08-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 42375
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.213"	3.215"	3.215"	3.214"	3.216"
B	4.946	4.966		4.959"	4.959"	4.958"	4.960"	4.958"
C	0.718	0.738		.730"	.728"	.728"	.728"	.734"
D	0.090	0.110		.098"	.099"	.099"	.099"	.097"
E	3.564	3.584		3.576"	3.577"	3.576"	3.576"	3.577"
F	0.022	0.042		.032"	.032"	.032"	.032"	.032"
G	3.444	3.464		3.454"	3.454"	3.454"	3.453"	3.454"
H	0.112	0.132		.121"	.120"	.120"	.121"	.119"
I	2.170	2.190		2.184"	2.183"	2.184"	2.184"	2.183"
J	4.451	4.471		4.463"	4.465"	4.462"	4.462"	4.463"
K	0.413	0.433		.423"	.423"	.423"	.423"	.423"
L	0.913	0.933		.923"	.923"	.923"	.923"	.920"
M								
N								
O								
P								

Measured by: J.F. Date: 08/10/04

Audited by: SA Date: 08/10/04

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 42375
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.216"	3.214"	3.215"	3.216"	3.215"
B	4.946	4.966		4.958"	4.958"	4.958"	4.958"	4.958"
C	0.718	0.738		.730"	.730"	.728"	.730"	.728"
D	0.090	0.110		.097"	.099"	.099"	.099"	.099"
E	3.564	3.584		3.579"	3.577"	3.576"	3.576"	3.576"
F	0.022	0.042		.032"	.032"	.032"	.032"	.032"
G	3.444	3.464		3.456"	3.454"	3.453"	3.453"	3.454"
H	0.112	0.132		.122"	.120"	.120"	.120"	.120"
I	2.170	2.190		2.185"	2.185"	2.184"	2.183"	2.183"
J	4.451	4.471		4.466"	4.463"	4.463"	4.463"	4.463"
K	0.413	0.433		.423"	.423"	.423"	.423"	.423"
L	0.913	0.933		.923"	.923"	.923"	.923"	.923"
M								
N								
O								
P								

Measured by: J.F. 08/10/04 Date: 08/10/04

Audited by: SA 08/10/04 Date:

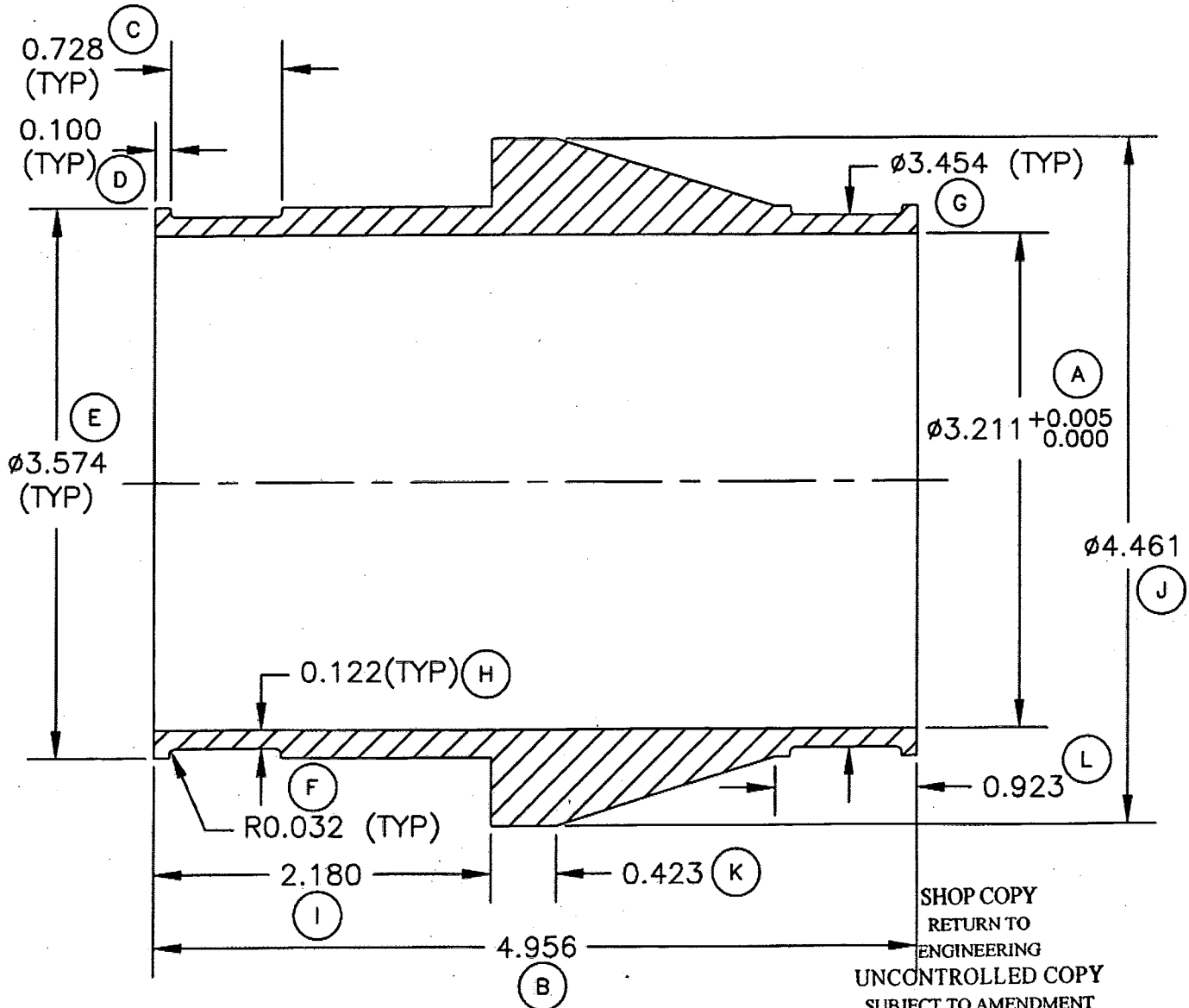
Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED  
03-07-01 *[Signature]*



D2940-1 TURNING DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42375

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.